

Work Order ID 133093

Tuesday, May 26, 2015 12:43:56 PM

133093

Page 1

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd, Out
 Start Date: 5/26/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MJ Date: **MAY 26 2015** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2571	F

100 ***100*** HAAS CNC VERTICAL MACHINING #1 0.00 12 0 DAS 40 9-89
 HAAS 1
 HAAS CNC vertical machine #1

Memo
 Program Batch No. **133093**
 Double check by: FK
 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect

15/06/28
 DAS 44 9-89 15/07/09

110 ***110*** CONVENTIONAL MILLING MACHINE 0.00 12 0 DAS 40 9-89
 Mill Conv
 Conventional Milling Machine

Memo
 Machine keyway as per dwg D2571 & D2572

15/06/28
 DAS 44 9-89 15/07/09

DQA: AV Date: 15/07/28

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: RAI Date: 15/07/27Work Order update only ☐

Work Order: <u>133093</u> Part No. <u>D2571</u> NCR No. <u>15-5212</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>15/07/03</u>	Step #: <u>100</u>	QTY Effective: <u>1</u>		MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u> <u>15/7/17</u>																																																																	
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Dimension "V" .240 ± .010 is at .228 Wrong offset was corrected By The Operator.			Acceptable. Drop load on cfi tube on the order of 18,000 lb. Yield bearing strength on order of 0.240 x 0.375 x 100 Ksi = 9000 lb x 4 fasteners. Sufficiently strong by inspection.																																																																		
			Completed By <u>DAS</u> <u>40</u> <u>9-89</u> <u>15/07/03</u> Lead hand / Supervisor Approval Verification <u>08</u> <u>9-89</u> <u>15/07/03</u> QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>15-07-22</u>																																																																		
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133093

Tuesday, May 26, 2015 12:43:56 PM

133093

Page 4

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Fwd, Out

Stop ***NS2***

Start Date: 5/26/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ

JUL 22 2015

MLJ JUL 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, May 26, 2015 12:43:56 PM

Page 1

Work Order ID: 133093

133093

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 *D6101-007* Saddle Billet		Manufactured	No			100	Each	27.0000	1	12			
									**	12		DAS 20 9-89	15-06-24

Location	Loc Qty	Loc Code
MAT041	19	
127646	1	
131095	18	
MAT044	8	
116083	1	
120494	7	

132 722

11

DQA: _____ Date: _____

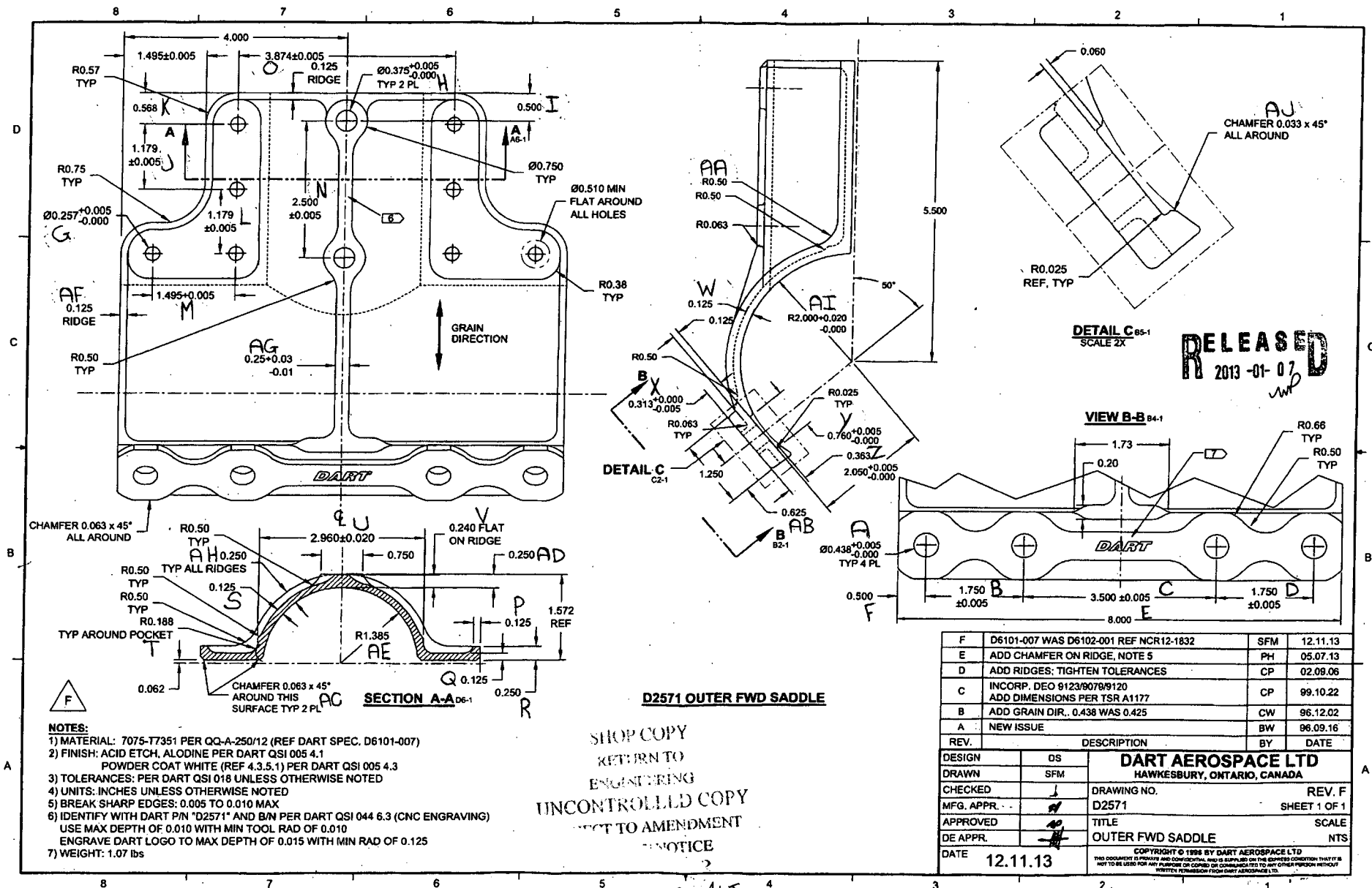


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



D2571 OUTER FWD SADDLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO AMENDMENT
NOTICE

133 093 ML5
150526

RELEASED
2013-01-07
JMP

DART AEROSPACE LTD		Work Order: 133093
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.442	.439	.438	.438		
B	1.745	1.755		1.760	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.760	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.501	.499	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.277	.377	.377		
I	0.490	0.510		.500	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.565	.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.498	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.121	.123	.123	.122		
R	0.240	0.260		.251	.253	.253	.251		
S	0.115	0.135		.125	.120	.122	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.959	2.958	2.958		
V	0.230	0.250		.248	.228	.242	.242		
W	0.115	0.135		.119	.119	.120	.119		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.629	.629	.629		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.250	.250	.249	.249		
AE	1.375	1.395		1.387	1.3897	1.3900	1.3896		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.255	.250	.250	.250		
AH	0.240	0.260		.245	.245	.245	.245		
AI	2.000	2.020		2.000	2.0025	2.0044	2.0032		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject DAS

40

Measured by:	9-89
Date:	15/06/29

Audited by:	DAS
Date:	15/07/15
	08
	9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 133093
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.005	8.000	8.000		
F	0.490	0.510		.504	.501	.500	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.504	.503	.499	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.569	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.121	.122	.121	.121		
R	0.240	0.260		.251	.252	.251	.252		
S	0.115	0.135		.126	.124	.123	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.241	.241		
W	0.115	0.135		.117	.122	.119	.119		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.253	.250	.251	.250		
AE	1.375	1.395		1.3896	1.3911	1.389	1.3895		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.245	.250	.249	.247		
AI	2.000	2.020		2.0034	2.0052	2.004	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by:	FR
Date:	15/07/04

Audited by:	D.A.	DAS
Date:	15/07/15	08
		9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg.Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 133093
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.374	.374	.377		
I	0.490	0.510		.505	.503	.504	.505		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.572	.571	.571	.572		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.121	.122	.122	.122		
R	0.240	0.260		.251	.253	.253	.252		
S	0.115	0.135		.117	.121	.123	.121		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.242	.240	.240		
W	0.115	0.135		.123	.119	.118	.116		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.060	.060	.060	.060		
AD	0.240	0.260		.251	.251	.250	.250		
AE	1.375	1.395		1.3895	1.391	1.390	1.390		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.247	.247	.248	.248		
AI	2.000	2.020		2.005	2.006	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject				✓	✓	✓	✓		

Measured by: <u>FK</u>
Date: <u>15/07/05</u>

Audited by: <u>Da</u>	BAS
Date: <u>15/07/15</u>	08
	9-89

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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